

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-012077**Date Inspected:** 09-Feb-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Lilin	CWI Present:	Yes	No
Inspected CWI report:	Yes No N/A	Rod Oven in Use:	Yes No N/A	
Electrode to specification:	Yes No N/A	Weld Procedures Followed:	Yes No N/A	
Qualified Welders:	Yes No N/A	Verified Joint Fit-up:	Yes No N/A	
Approved Drawings:	Yes No N/A	Approved WPS:	Yes No N/A	
		Delayed / Cancelled:	Yes No N/A	
Bridge No:	34-0006	Component:	Tower	

Summary of Items Observed:

On this day CALTRANS OSM Quality Assurance (QA) Inspector Shailesh Gaikwad was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

This QA Inspector observed the following work in progress:

BAY 10

Repair Welding

This QA Inspector observed ZPMC qualified welding personnel identified as 066236, Perform Shielded Metal Arc Welding (SMAW) on North Tower lift4 B/C corner. The weld identified as NSTL4-3B/L-5B, near 116M Diaphragm. ZPMC CWI Identified as Gang Liang Zhu, with Temporary welding repair report and Y location is 26100mm. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-SMAW-2G (2F)- Repair. for more information see attached photos.

Repair Welding

This QA Inspector observed ZPMC qualified welding personnel identified as 066236, Perform Shielded Metal Arc Welding (SMAW) on North Tower lift4 B/C corner. The weld identified as NSTL4-3B/L-5B. ZPMC CWI Identified as Gang Liang Zhu, with Temporary welding repair report and Y location is 18200mm. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-SMAW-2G (2F) - Repair.

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Repair Welding

This QA Inspector observed ZPMC qualified welding personnel identified as 066733, Perform Flux Core Arc Welding (FCAW) on North Tower lift4 B/C corner. The weld identified as NSTL4-3B/L-5B. ZPMC CWI Identified as Gang Liang Zhu, with Temporary welding repair report and Y location is 850mm. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-FCAW-2G (2F) - Repair.

Repair Welding

This QA Inspector observed ZPMC qualified welding personnel identified as 057258, Perform Shielded Metal Arc Welding (SMAW) on Saddle plate. The weld identified as ND1-BPSA5-2-1-5A. ZPMC CWI Identified as Liliin, with Critical welding repair report, CWR-T-CWR539. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-485-SMAW-2G (2F)-FCM-Repair-1. For more Information see attached photos.

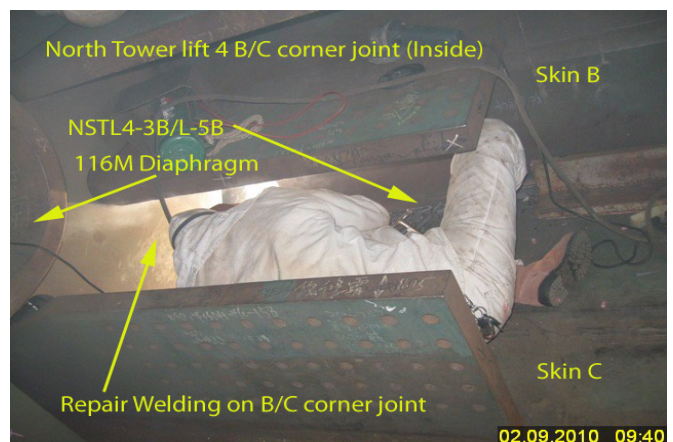
BAY 11:

This QA Inspector observed ZPMC qualified welding personnel identified as 040699. Perform Submerged Arc Welding (SAW) on Tower Flange Plate. Joint identified ED1-SA4-68-135M-1-1B, ED1-SA4-68-135M-2-1B, ED1-SA4-68-135M-3-1B, ZPMC CWI Identified as Yu Dong Ping. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-3221-Tc-U5-S-1.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.



Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Skyler Guest phone: 15000422360, who represents the Office of Structural Materials for your project.

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Inspected By:	Gaikwad,Shailesh	Quality Assurance Inspector
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Reviewed By:	Clifford,William	QA Reviewer
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